

Work Order ID 84250

May-08-12 12:58:27 PM

84250

Page 1

Item ID: D4640-11

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Floor Protector

Start Date: 08/05/2012 Start Qty: 1.00

1

Cust Item ID:

Required Date: 22/05/2012 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals:

Process Plan: MLJ

Date: 12/05/08

Tooling:

Date:

Run Start *NR1*

QC:

Date:

SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

D4640

A

100

0.00

100

Waterjet

FLOW CNC Waterjet

Memo

Cut as per dwg

Prog Rev: A

Dwg Rev: B

Deburr as required

0.00

110

QC2- Inspect parts off machine FAI/FAIB

0.00

110

QC

Quality Control

Memo

0.00

1 0 JM/SA 12-5-9

1 0 JM/SA 12-5-9

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 84250

84250

Page 2

May-08-12 12:58:27 PM

Item ID: D4640-11 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Floor Protector
 Start Date: 08/05/2012 Start Qty: 1.00 ***1*** Cust Item ID:
 Required Date: 22/05/2012 Req'd Qty: 1.00 ***1*** Customer:
 Reference:

Approvals: Process Plan: Date: Tooling: Date: Run Start ***NR1***
 QC: Date: SPC (Y/N): Date: Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120	QC8- Inspect parts - second check	0.00							
120		0.00							
QC	Memo								
Quality Control									
130	Identify as per dwg & Stock Location: _____	0.00							
130		0.00							
Packaging	Memo								
Packaging									
140	QC21- Final Inspection - Work Order Release	0.00							
140		0.00							
QC	Memo								
Quality Control									

(Handwritten mark)

(Handwritten signature)

12/5/10

ML5 12/05/10

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

May-08-12 12:58:30 PM

Page 1

Work Order ID: 84250

84250

Parent Item: D4640-11

D4640-11

Parent Item Name: Floor Protector

Start Date: 08/05/2012

Required Date: 22/05/2012

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP REV:A 12.05.08 NEW ISSUE DD VERF:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MLEXS.093-F6006-02		Purchased	No			100	sf	272.7275	10.795	11.36316			

MI FXS 093-F6006-02

**

GE PLASTICS LEXAN SHEET

Location

Loc Qty

Loc Code

therm

272.7274879

106751

97.9159079

110877

174.81158

110877

JM/SA
12-5-8

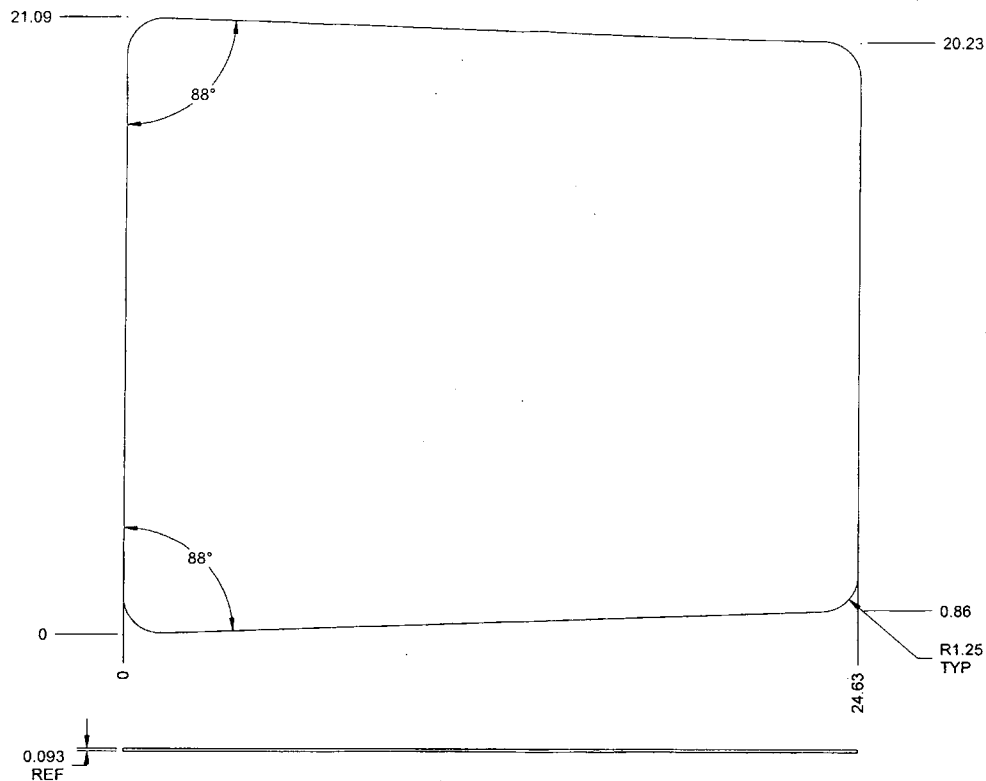
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



D4640-1 RH FORWARD WALL PROTECTOR
TEXTURED SIDE SHOWN

NOTES:

- 1) MATERIAL: F6006-701 BLACK LEXAN SHEET (SUEDE/POLISHED TEXTURE) 0.093 THICK
REF DART SPEC MLEXS.093-F6006-02
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1 ON SMOOTH SIDE
- 7) WEIGHT: 2.00 lbs
- 8) CHECK PER TEMPLATE DT8924

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER

NO. 84250 MLJ
12/05/08

RELEASED
2012-05-07
MP

A		NEW ISSUE		DC		12.04.20	
REV.		DESCRIPTION		BY		DATE	
DESIGN		<i>DC</i>		DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA			
DRAWN		<i>DC</i>					
CHECKED		<i>DC</i>		DRAWING NO.		REV. A	
MFG. APPR.		<i>DC</i>		D4640		SHEET 1 OF 9	
APPROVED		<i>MP</i>		TITLE		SCALE	
DE APPR.		<i>MP</i>		BAGGAGE PROTECTOR NTS			
DATE		12.04.20		COPYRIGHT © 2012 BY DART AEROSPACE LTD <small>THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>			

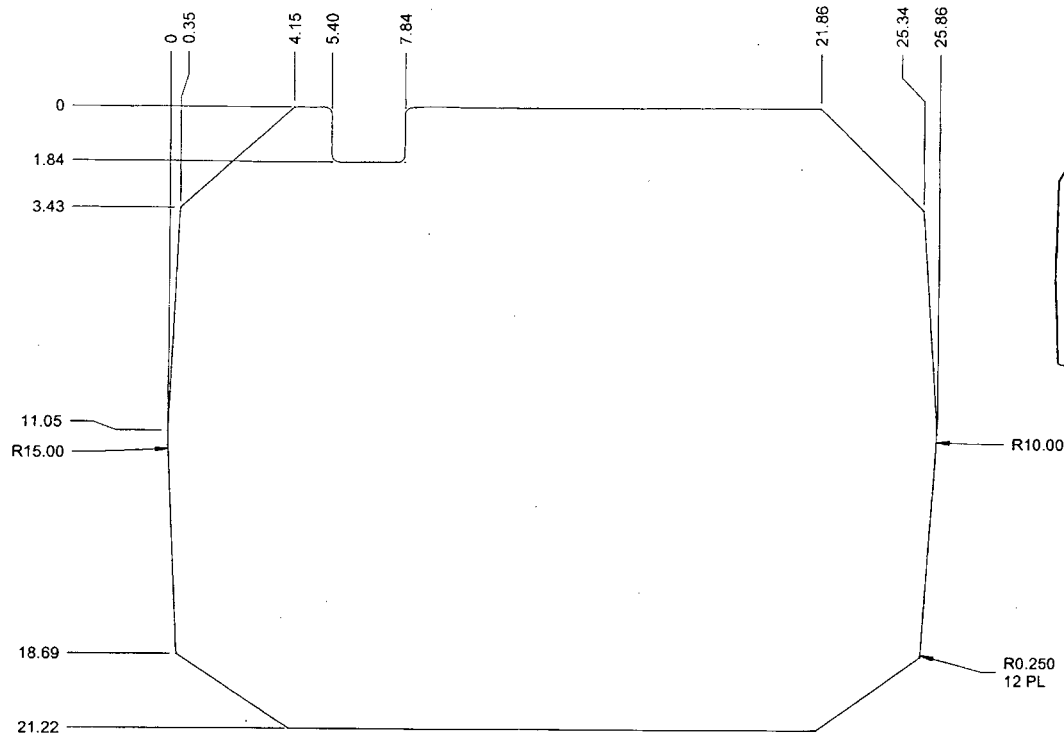
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



D4640-3 FORWARD WALL PROTECTOR
TEXTURED SIDE SHOWN

RELEASE
2012-05-07
JW

NOTES:

- 1) MATERIAL: F6006-701 BLACK LEXAN SHEET (SUEDE/POLISHED TEXTURE) 0.093 THICK
REF DART SPEC MLEXS.093-F6006-02
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1 ON SMOOTH SIDE
- 7) WEIGHT: 2.07 lbs
- 8) CHECK PER TEMPLATE DT8925

DESIGN	JS	DART AEROSPACE LTD	
DRAWN	BC	HAWKESBURY, ONTARIO, CANADA	
CHECKED	JS	DRAWING NO.	REV. A
MFG. APPR.	FE	D4640	SHEET 2 OF 9
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Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

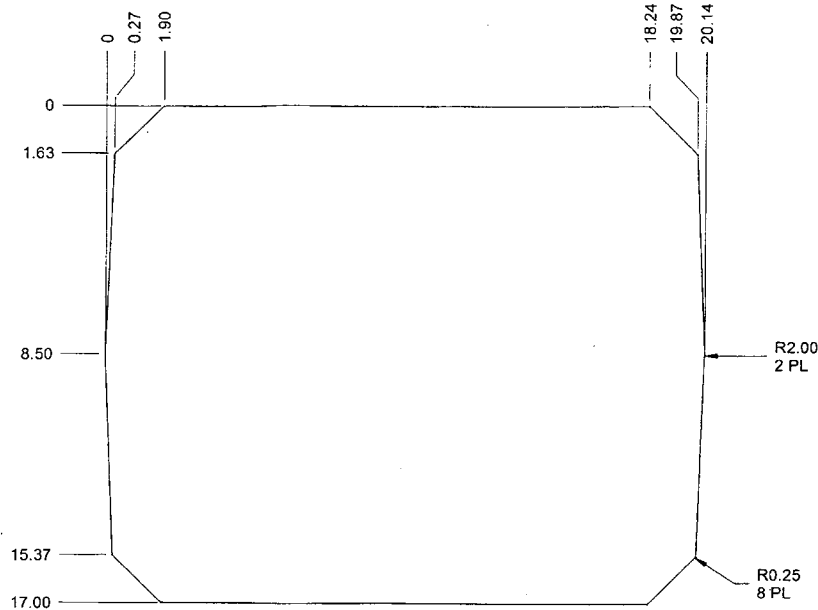
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

0.093
REF



84250

D4640-7 AFT WALL PROTECTOR
TEXTURED SIDE SHOWN

RELEASED
2012-05-07
JP

NOTES:

- 1) MATERIAL: F6006-701 BLACK LEXAN SHEET (SUEDE/POLISHED TEXTURE) 0.093 THICK
REF DART SPEC MLEXS.093-F6006-02
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1 ON SMOOTH SIDE
- 7) WEIGHT: 1.34 lbs
- 8) CHECK PER TEMPLATE DT8927

DESIGN	JB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	JC		
CHECKED	JB	DRAWING NO.	REV. A
MFG. APPR.	FE	D4640	SHEET 4 OF 9
APPROVED	JP	TITLE	SCALE
DE APPR.	JP	BAGGAGE PROTECTOR	NTS
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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

8

7

6

5

4

3

2

1

D

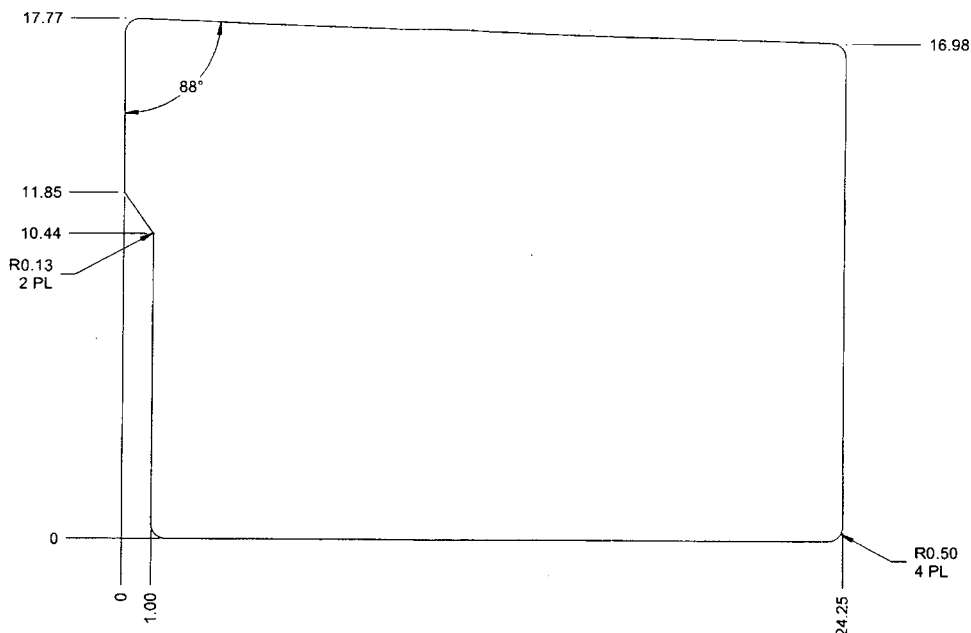
D

C

C

B

B

0.093
REF

D4640-9 RH AFT WALL PROTECTOR
TEXTURED SIDE SHOWN

NOTES:

- 1) MATERIAL: F6006-701 BLACK LEXAN SHEET (SUEDE/POLISHED TEXTURE) 0.093 THICK
REF DART SPEC MLEXS.093-F6006-02
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1 ON SMOOTH SIDE
- 7) WEIGHT: 1.65 lbs
- 8) CHECK PER TEMPLATE DT8928

DESIGN	JS	DART AEROSPACE LTD	
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CHECKED	JS	DRAWING NO.	REV. A
MFG. APPR.	JS	D4640	SHEET 5 OF 9
APPROVED	JS	TITLE	SCALE
DE APPR.	JS	BAGGAGE PROTECTOR	MTS
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8

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A

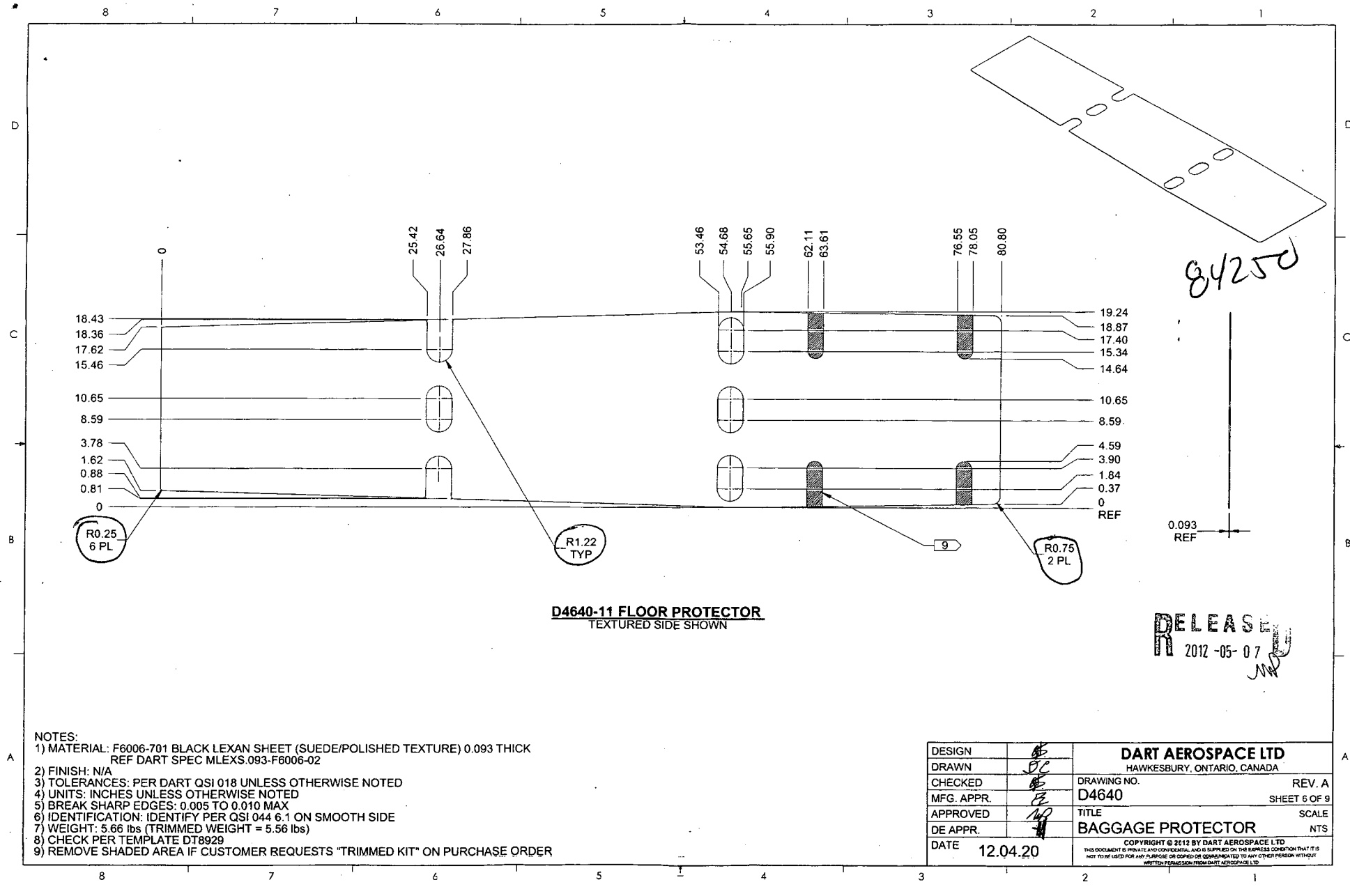
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

8

7

6

5

4

3

2

1

D

D

C

C

B

B

A

A

0.093
REF

16.75

9.59

R0.50
4 PL

6.84

0.67

0

1.50

D4640-13 DOOR PROTECTOR
TEXTURED SIDE SHOWN

89°

89°

27.25

17.43

R3.50
4 PL

0

84250

RELEASED
2012-05-07
MP

NOTES:

- 1) MATERIAL: F6006-701 BLACK LEXAN SHEET (SUEDE/POLISHED TEXTURE) 0.093 THICK
REF DART SPEC MLEXS.093-F6006-02
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1 ON SMOOTH SIDE
- 7) WEIGHT: 1.78 lbs
- 8) CHECK PER TEMPLATE DT8930

DESIGN	AB	DART AEROSPACE LTD	
DRAWN	BC	HAWKESBURY, ONTARIO, CANADA	
CHECKED	BE	DRAWING NO.	REV. A
MFG. APPR.	FE	D4640	SHEET 7 OF 9
APPROVED	MP	TITLE	SCALE
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8

7

6

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4

3

2

1

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

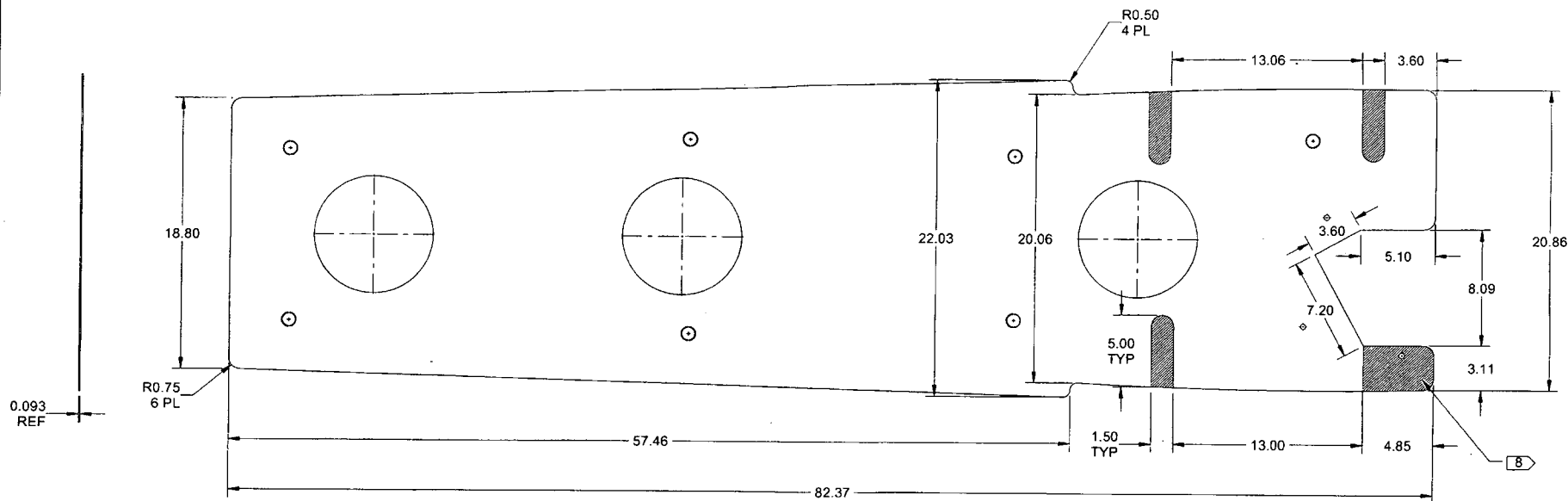
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

24200



D4640-15 CEILING PROTECTOR
TEXTURED SIDE SHOWN

RELEASED
2012-05-07
JNT

NOTES:

- 1) MATERIAL: F6006-701 BLACK LEXAN SHEET (SUEDE/POLISHED TEXTURE) 0.093 THICK
REF DART SPEC MLEXS.093-F6006-02
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1 ON SMOOTH SIDE
- 7) WEIGHT: 5.84 lbs (TRIMMED WEIGHT = 5.84 lbs)
- 8) REMOVE SHADED AREA IF CUSTOMER REQUESTS "TRIMMED KIT" ON PURCHASE ORDER

DESIGN	XDF	DART AEROSPACE LTD	
DRAWN	DC	HAWKESBURY, ONTARIO, CANADA	
CHECKED	ES	DRAWING NO.	REV. A
MFG. APPR.	FE	D4640	SHEET 8 OF 9
APPROVED	WJ	TITLE	SCALE
DE APPR.	TH	BAGGAGE PROTECTOR	NTS
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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order: 84250
Description: Floor Protector		Part Number: 04640-11
Inspection Dwg: 04640-11 Rev: A		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.81	+/- 0.030	0.821	✓		vern	HB-02
0.88	+/- 0.030	0.89	✓		vern	HB-02
1.62	+/- 0.030	1.641	✓		vern	HB-02
3.78	+/- 0.030	3.769	✓		vern	HB-02
8.59	+/- 0.030	8.588	✓		vern	Prod-w-J-02
10.65	+/- 0.030	10.65	✓		vern	Prod-w-J-02
15.46	+/- 0.030	15.46	✓		MT	HB-01
17.62	+/- 0.030	17.62	-		MT	HB-01
18.36	+/- 0.030	18.36	✓		MT	HB-01
18.43	+/- 0.030	18.43	-		MT	HB-01
25.42	+/- 0.030	25.42	-		MT	HB-01
26.64	+/- 0.030	26.64	✓		MT	HB-01
27.86	+/- 0.030	27.86	✓		MT	HB-01
53.46	+/- 0.030	53.46	✓		MT	HB-01
54.68	+/- 0.030	54.68	-		MT	HB-01
55.65	+/- 0.030	55.65	✓		MT	HB-01
55.90	+/- 0.030	55.90	✓		MT	HB-01
62.11	+/- 0.030	62.11	✓		MT	HB-01
63.61	+/- 0.030	63.61	✓		MT	HB-01
76.55	+/- 0.030	76.55	✓		MT	HB-01
78.05	+/- 0.030	78.05	✓		MT	HB-01
80.80	+/- 0.030	80.80	✓		MT	HB-01
80.25	+/- 0.030	80.25	✓		RG	

Measured by: JM
Date: 12-5-9

Audited by: J
Date: 12/5/05

Prototype Approval:	N/A
Date:	N/A

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	